

5/24

|                         |              |       |
|-------------------------|--------------|-------|
| DART AEROSPACE LTD      | Work Order:  | 23460 |
| Description: Gas Spring | Part Number: | D2807 |
| Dwg: D2807 Rev: C       | Qty:         | 60    |

Page 1 of 1

| Step | Location | Procedure   | By | Date     | Qty |
|------|----------|---|----|----------|-----|
| 1    | DC       | Issue Traveler  | CH | 05.07.19 | 60  |
| 2    | PG       | Issue P/O: <u>2008151</u><br>Order as per Dwg D2807<br>Possible supplier: ArvinMeritor Motion Control Systems<br><b>Material release note is required</b> | U  | 05.06.02 | 60  |
| 3    | RG       | Receive and Inspect for transit damage<br><b>Ensure the material release note is attached</b>   | DL | 05/07/19 | 59  |
| 4    | QC6      | Inspect dimensions as per Dwg D2807   | Z  | 06.01.10 | 35  |
| 5    | GA       | Install lugs and crimp as per Dwg D2807<br><b>Pick:</b><br>Qty Part Number Description Batch<br>2 D2807-3 Lug 1 B 23915 623479                            | FF | 06-01-11 | 35  |
| 6    | QC5      | Inspect work to Step 5  | Z  | 06-01-11 | 35  |
| 7    | ST       | Identify and Stock<br>Loc: 379  | CD | 06/01/11 | 33  |
| 8    | AC       | Cost / part:  |    |          |     |
| 9    | DC       | Close W/O<br>Inspect Level 21   |    |          |     |

| Rev | Date     | Change                             | Revised By | Approved   |
|-----|----------|------------------------------------|------------|------------|
| A   | 00.11.09 | New Issue                          | EC         |            |
| B   | 00.11.15 | Added step 6                       | EC         |            |
| C   | 05.04.28 | Reformat; Added Step 6 & 7         | KJ/JLM     | <i>JLM</i> |
| D   | 05.06.21 | Removed painting; Changed supplier | KJ/JLM     | <i>JLM</i> |

RELEASED  
*CH 06-01-11*

## WORK ORDER CHANGES

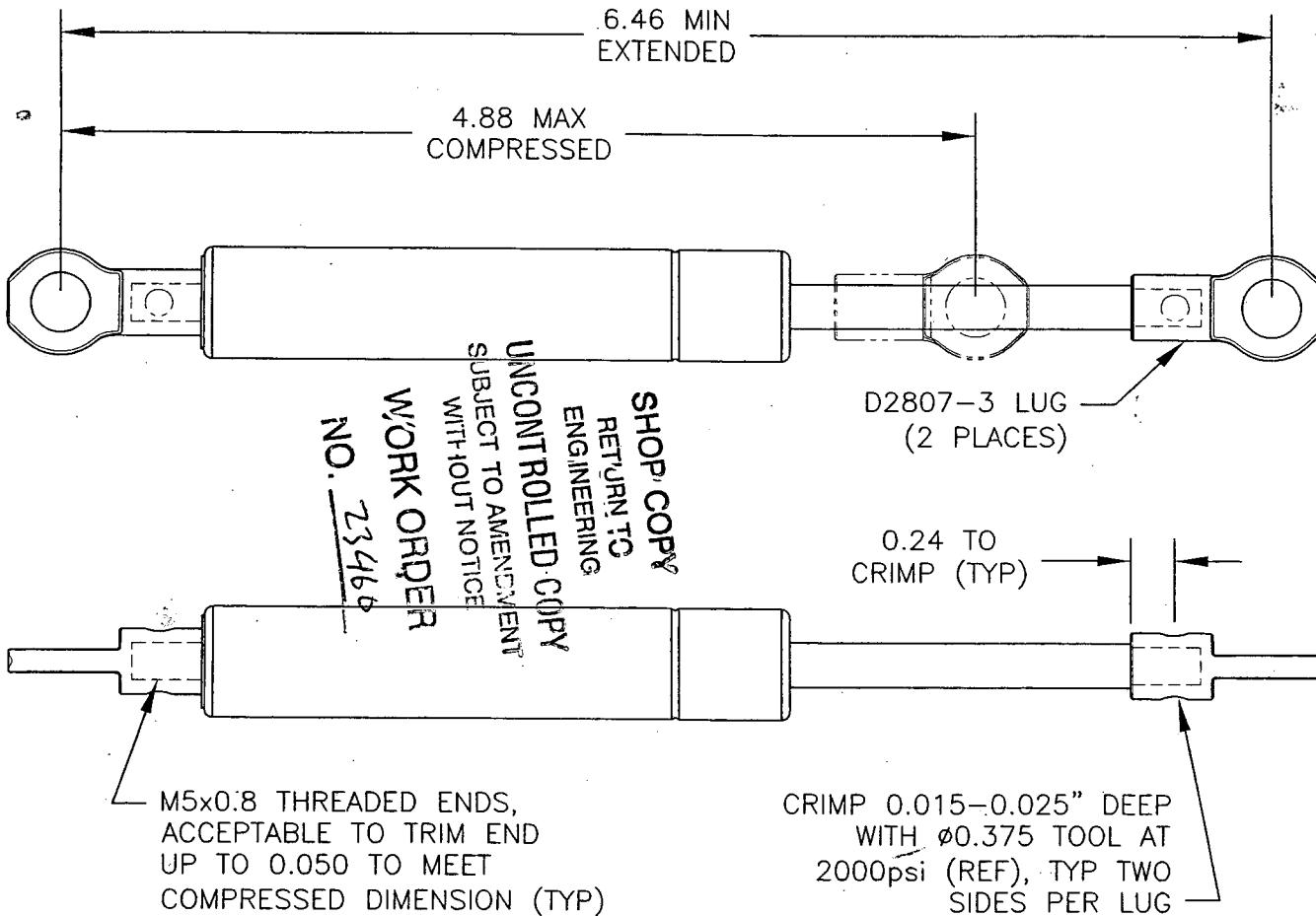
| DATE     | STEP | PROCEDURE CHANGE  | By | Date     | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|----------|------|---|----|----------|-----|---------------------------------|--------------------------|
| 06/01/10 | 5    | write the dt 8791 sig on W10<br><br>Add to step 5 permanent change of | SB | 06/01/10 |     |                                 | <i>2</i><br>06.01.10     |
|          |      |   |    |          |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                 |                           |                        |                          |
|----------|------|----------------------------------|-----------------------------|----------------------------------|-----------------|---------------------------|------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                 | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|          |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date  |                           |                        |                          |
| 05/01/10 | 5    | 1 piece thread<br>was damaged    | <i>SB</i><br>06.01.10       | Scrap - destroy                  | Jan 10-06<br>FF | <i>2</i><br>06.01.10      | <i>18</i><br>06.01.10  | <i>2</i><br>06.01.10     |
|          |      |                                  |                             |                                  |                 |                           |                        |                          |
|          |      |                                  |                             |                                  |                 |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



### D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

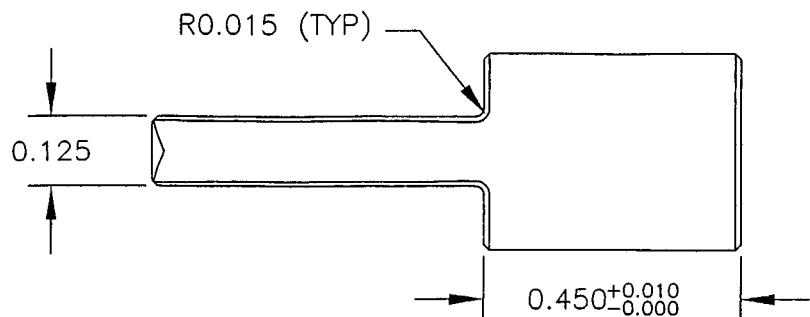
**DART**  
HAWKESBURY, ONTARIO, CANADA

| DESIGN             | DRAWN BY           | DART AEROSPACE LTD          |
|--------------------|--------------------|-----------------------------|
| CP                 | CP                 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED            | APPROVED           | DRAWING NO.                 |
| <i>[Signature]</i> | <i>[Signature]</i> | D2807                       |
| 05.05.25           |                    | SCALE                       |
| A                  | 00.11.03           | 1:1                         |
| B                  | 05.03.16           |                             |
| C                  | 05.05.25           |                             |
|                    |                    | TITLE                       |
|                    |                    | GAS SPRING                  |

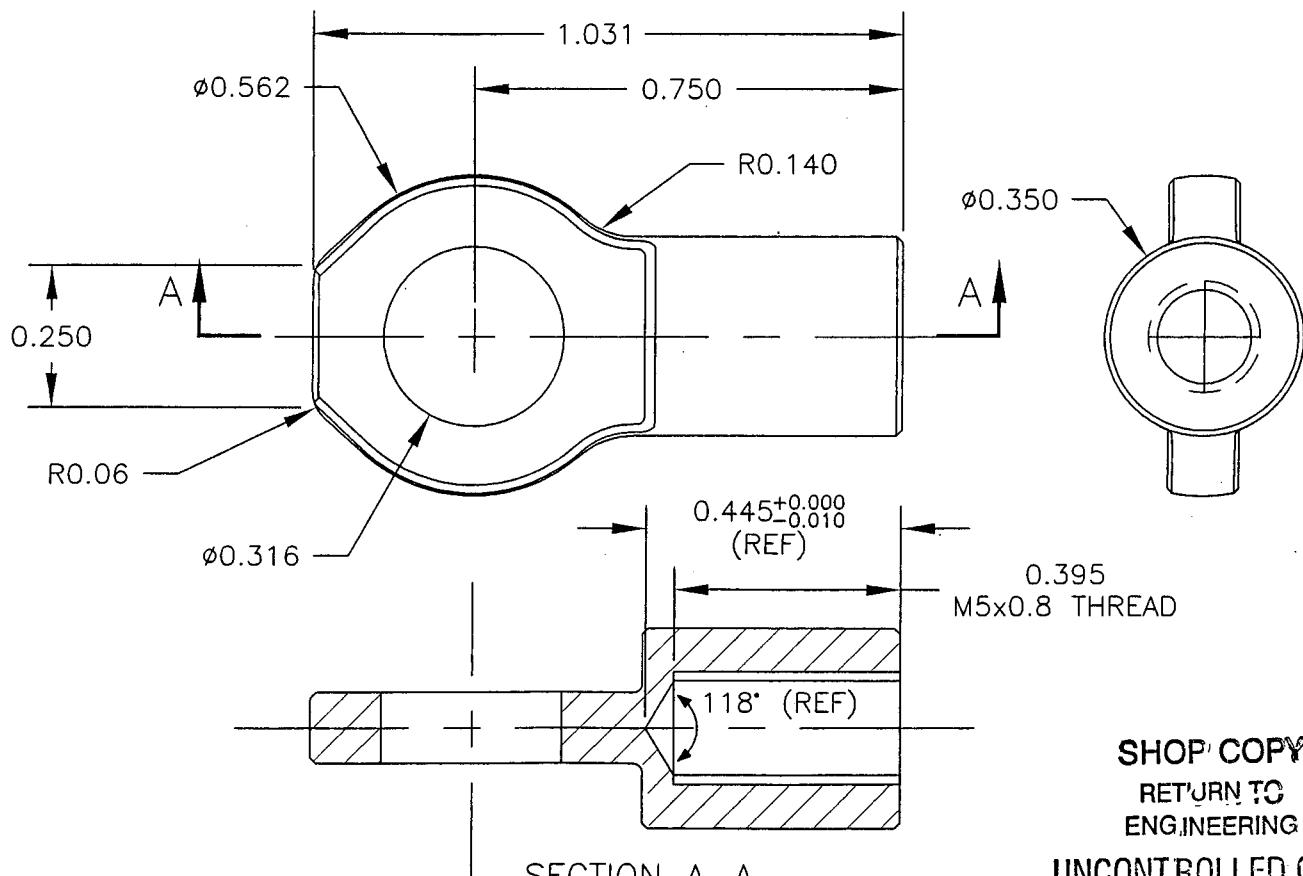
**RELEASED**  
*[Signature]*



|                               |                                |   |
|-------------------------------|--------------------------------|---|
| DESIGN<br>CP                  | DRAWN BY<br>CP                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2807                              |
| DATE<br>05.05.25              | TITLE<br>GAS SPRING            | REV. C<br>SHEET 2 OF 2<br>SCALE<br>3:1            |



RELEASED  
05.06.16 *[Signature]*



SECTION A-A

D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 23460

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 31, 2005  
03:20 pm

|                   |   |              |                  |   |                               |
|-------------------|---|--------------|------------------|---|-------------------------------|
| Work Order No     | : | 0023460      | Department Code: |   |                               |
| Project Name      | : | D2807        | Burden Flags     | : | NNNNNNN                       |
| Project For       | : | WK524        | WO Status        | : | Open                          |
| Work Order Type   | : | Main         | Invoice State    | : | Not Invoiced                  |
| Main WO Number    | : |              | Invoice Date     | : |                               |
| House Part Number | : | D2807        | Invoice Number   | : |                               |
| Description       | : | Support Prop | Invoice Amount   | : | 0.00                          |
| Manufactured      | : | Yes          |                  |   |                               |
| Amount Req'd      | : | 60           |                  |   |                               |
| Amount Done       | : | 0            | Order Entry No   | : |                               |
| Start Date        | : | 05-31-05     | OE Value         | : | 0.00                          |
| Est Finish Date   | : | 06-30-05     |                  |   |                               |
| Act Finish Date   | : |              | Est Mark Up      | : | 0.000%                        |
| Drawings Reqd     | : | No           | Actual Mark Up   | : | 0.000%                        |
| Ok for Approval   | : |              |                  |   |                               |
| Approval Rec'd    | : |              |                  |   | \$0 Posted to Finished Goods. |

|                   | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost     | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Cost  | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours  | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Cost   | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours   | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Cost    | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours    | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Cost     | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours         | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC               | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours       | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc.             | :         | 0.00   | 0.00   | 0.00   | 0.00    |
| =====             |           | =====  | =====  |        |         |
| Burden            | :         | 0.00   | 0.00   | 0.00   |         |
| =====             |           | =====  | =====  |        |         |
| Total Cost        | :         | 0.00   | 0.00   | 0.00   |         |
| Mark up           | :         | 0.000  | 0.000  |        |         |
| Selling Cost      | :         | 0.00   | 0.00   |        |         |

|                        | Estimated | Actual |      |
|------------------------|-----------|--------|------|
| Labour Hrs/Amount Done | :         | 0.00   | 0.00 |
| Profits/ (Loss)        | :         | 0.00   | 0.00 |

